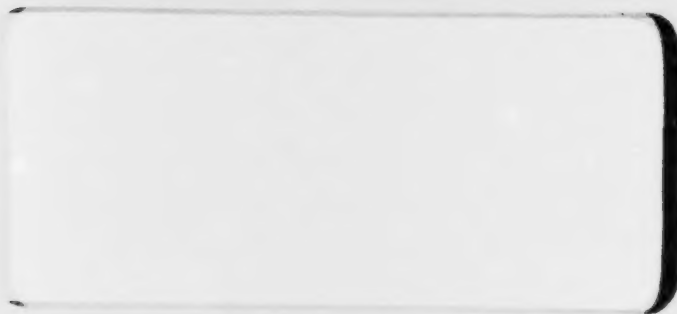
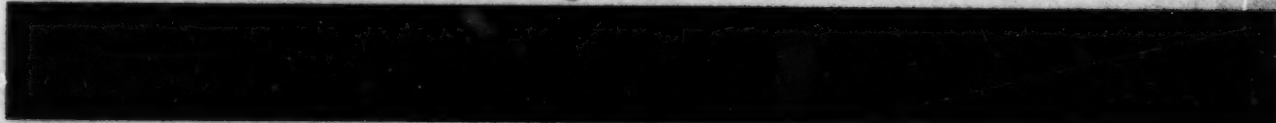


MANIT^{BA}

**Environmental Management Division
Environmental Control Services**



Environmental Control Programs



FILE: 1142
DATE: January 3, 1986

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Source Testing for Particulate Emissions

From the East Retort Stack

at Garry Memorial Crematorium

Winnipeg, Manitoba

1985

**Prepared by Kevin E. Reeve, B. Sc.,
Environmental Control Services,
Department of Environment and
Workplace Safety and Health.**

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ABSTRACT

During July 1985 three particulate source emission tests were conducted on the east pathological crematory at Garry Memorial Crematorium Ltd., Winnipeg, Manitoba. During the testing program the average particulate concentration, at mean stack CO₂ values was 0.14 grams per dry standard* cubic metre (g/dscm). When mean stack CO₂ values were corrected to 12%, the average particulate concentration increased to 0.22 g/dscm. The particulate test results are in general compliance with Manitoba Regulation 334/74, Clause 3(1) limiting particulate emissions from new incinerators to 0.23 g/dscm of dry flue gas when corrected to 12% CO₂.

* temperature 20°C, pressure 760 mm Hg

INTRODUCTION

In order to determine compliance with Manitoba Regulation 334/74, Clause 3(1), the Air Pollution Control Section conducted a stack sampling survey on the east (new) pathological crematory at Garry Memorial Crematorium Ltd., 1291 McGillivray Boulevard, Winnipeg, Manitoba in October, 1984. The results of these two emission tests revealed that the crematory was in non-compliance with Clause 3(1) of Regulation 334/74.

A follow-up survey was conducted in 1985 to determine if the crematory was then in compliance with the regulation. For the 1985 tests a new water cooled probe was used to avoid any of the metal fatigue problems normally associated with the intense heat in a crematory stack.

PROCESS DESCRIPTION

An all Crematory Corporation Model L-1701 dual chamber Crematory Retort (see Figure 1) is installed at Garry Memorial Crematorium. Drying, ignition and partial combustion of the Case (Corpse) occurs in the primary chamber. Air intake to the primary chamber is carefully controlled so that the rate of combustion and therefore the temperature is controlled. This prevents turbulent high velocity gases from developing which could transport ash particles into the secondary (afterburner) chamber. As a further precaution the flue gases exit downward into a settling chamber at the base of the afterburner so that any entrained ash particles are not emitted via the stack. Air to the secondary chamber is supplied in excess of stoichiometric requirements to ensure complete combustion.

The combustion products, mainly carbon dioxide and water vapor, exit through a 15 foot (4.6 m) steel stack with a 5 inch (12.7 cm) firebrick liner. The stack has an average inside diameter of 19.4 inches (49.2 cm).

A special start up sequence is utilized for the first cremation each day. The combustion blower is started first to purge the system 3 1/2 minutes prior to ignition of the afterburner. For the next 20 minutes the combustion blower and after burner are run continuously to preheat the secondary chamber. When the preheat cycle is completed a casket is inserted into the retort. After the door is fully closed the main burner is ignited. During the 2 hour cremation

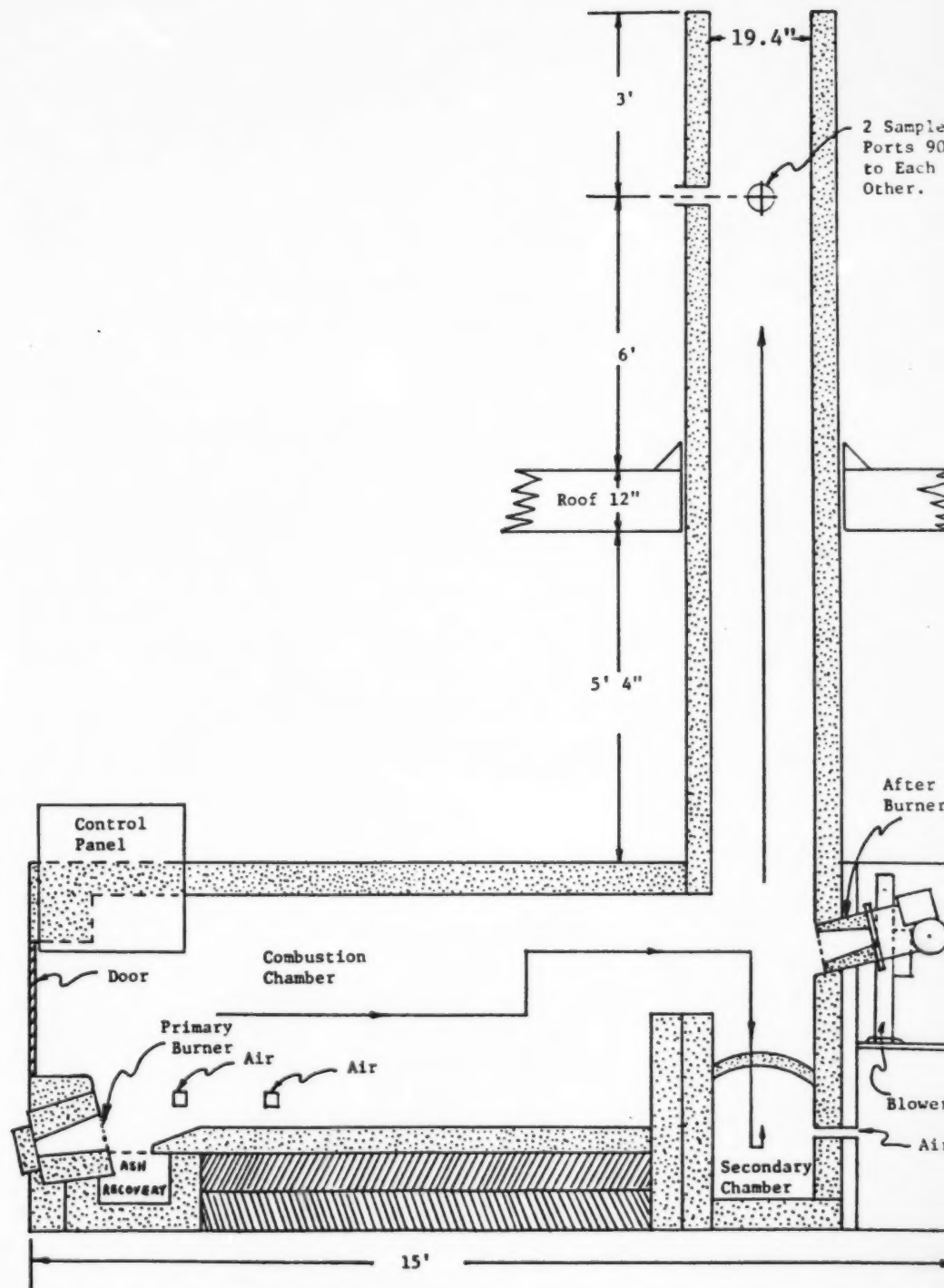


FIGURE 1: All Crematory Corp. Model L-1701 Retort as Installed at Garry Memorial Crematorium.

cycle a fuel saver device will automatically set the main burner in the low fire position whenever the temperature exceeds 1600°F (871°C). At the end of the 2 hour cycle a timer automatically turns off the retort burners. At this point a visual inspection of the Case is made -- if the cremation is complete the combustion blower alone is turned on for 1 1/4 hours to cool the retort down on the cooling cycle. If not the combustion blower is started, followed 3 1/2 minutes later by the afterburner and the main burner which are fired until the cremation is complete. After the cooling cycle is finished the cremains are removed.

When a second cremation is scheduled the same day the next preheat cycle is approximately five minutes or 800°F (427°C) on the temperature indicator. This cremation cycle remains the same as the first, however the cool down cycle is increased to 2 1/4 hours.

PROCESS SCHEDULE

During the sampling program one Case was cremated per test. The first casket (Test 1) was wooden while the second and third (Tests 2 and 3) were cardboard.

TEST PROCEDURES

All sampling was conducted through two ports located at right angles to each other (northwest and northeast) 12.5 feet (3.8 m) above the secondary chamber and 3 feet (0.9 m) below the top of the stack. This corresponds to 7.7 and 1.9 duct diameters respectively of unrestricted flow before and after the sampling location. Four points were sampled along each traverse according to Environmental Protection Service (EPS) Method A specifications. The sample points, located 1.3, 4.8, 14.5 and 18.1 inches (3.3, 12.2, 36.8 and 46.0 cm) respectively from the stack wall are depicted on a cross section of the stack in Figure 2. Sampling intervals were five minutes per point.

Source emission testing was conducted according to EPS Method E, with one exception. To eliminate metal fatigue caused by the high stack gas temperature, the probe was water cooled rather than electrically heated. Figure 3 illustrates the particulate stack sampling train. The sample was drawn into a 0.497 in. (12.62 mm) nozzle, through a stainless steel probe and into a miniature cyclone which removed particulate matter of greater than 10μ diameter. The sample was then passed through a Whatman 934 AH glass microfiber filter (supported by a porous fritted glass disc) which removed particulates of 0.3μ diameter and greater. Both the cyclone and the filter were heated to prevent moisture from condensing at that point. The sample was then passed through four 500 ml Greenburg-Smith impingers connected in series in an ice bath. The first, third and

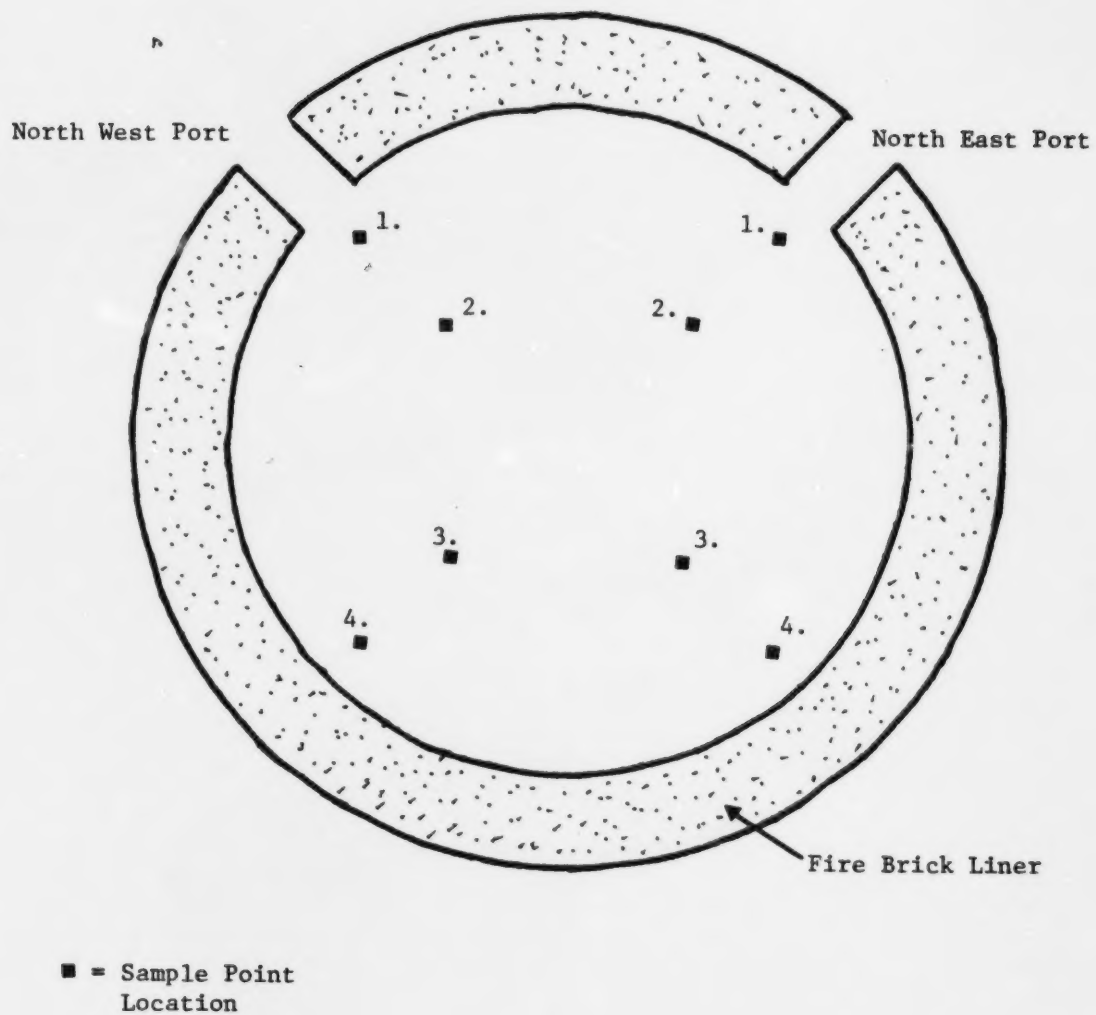


FIGURE 2. Stack Cross Section Depicting Sample Points.

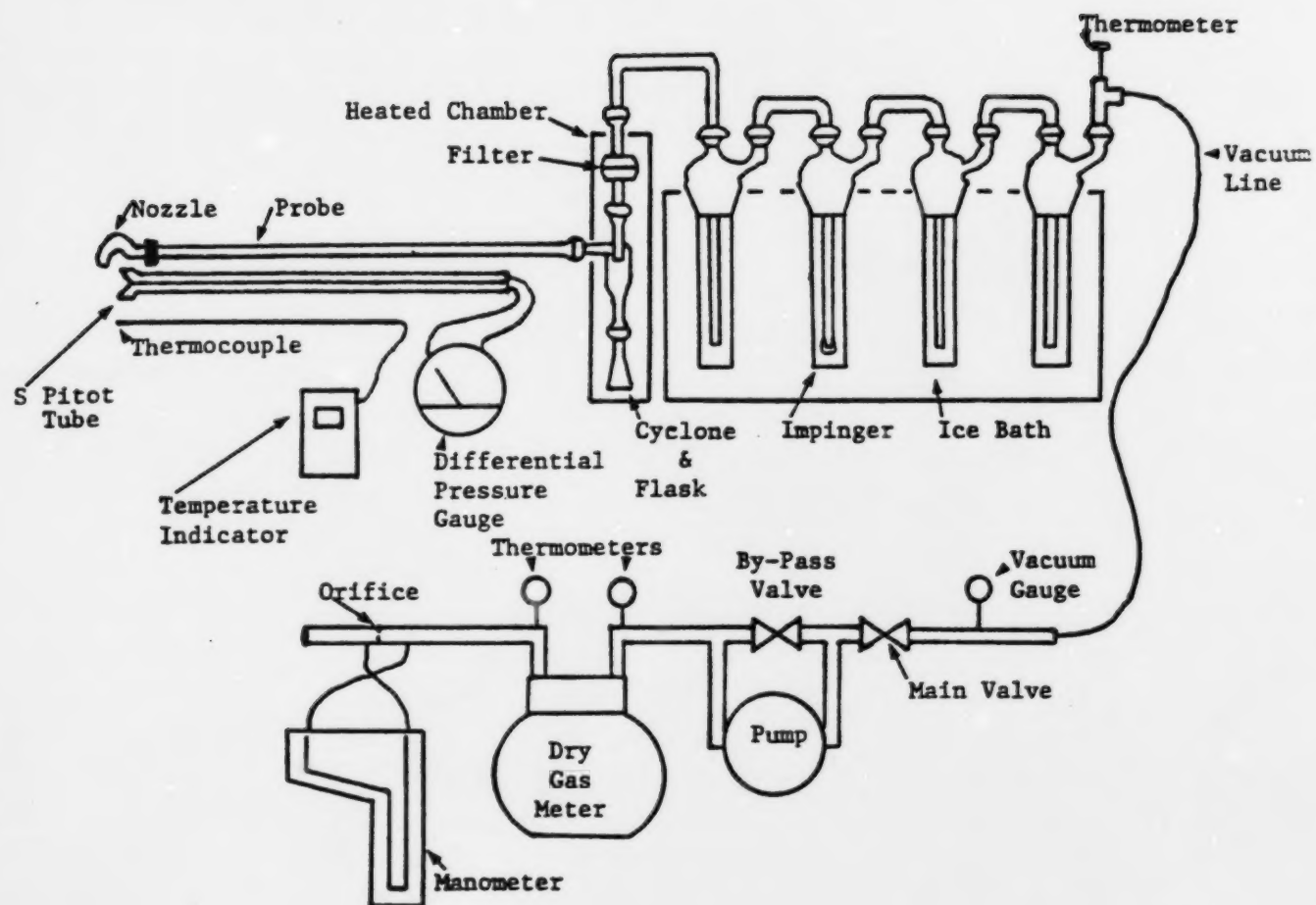


FIGURE 3. Particulate Stack Sampling Train

fourth impingers had modified straight tips while the second was of the standard design. The first and second impingers contained 100 ml of deionized water. The third impinger was initially empty while the fourth contained 200 grams of indicating silica gel to remove remaining moisture from the gas sample.

A Bendix Series 4500 Isokinetic Stack Sampler was used to extract the samples from the stack. Gas velocity in the stack was measured with an S type pitot tube and a Dwyer Magnehelic Differential Pressure Gauge (range 0 to 0.25" H₂O, minor division 0.005" H₂O). Dry gas meter and pitot tube calibration data sheets are located in Appendix A. A Hays-Republic Model 621A Gas Analyzer was used to determine CO₂, O₂ and CO content of the stack gas. Stack temperature was measured by a K type thermocouple.

After sample recovery from the stack train, samples were submitted to the W. M. Ward Technical Services Laboratory for gravimetric analysis of particulates. As the nozzle was not water cooled (and therefore subject to metal fatigue) the particulate matter extracted from it was not included in the sample submitted to the lab.

The sampling team consisted of Kevin Reeve and Tim Higham.

RESULTS

During the testing program the crematory retort was operated according to manufacturers instructions. Important sampling parameters are summarized in Table 1.

Source emission data are summarized in Table 2. Refer to Appendices B, C and D respectively for velocity profiles, field data sheets and the laboratory analytical reports.

TABLE 1: SUMMARY OF SAMPLING PARAMETERS

TEST NUMBER	1			2			3		
	July 9, 1985			July 10, 1985			July 10, 1985		
SAMPLING DATE									
SAMPLING DURATION, minutes	40			40			40		
SAMPLE VOLUME @ METER CONDITIONS, ft ³	17.906			16.285			15.001		
SAMPLE VOLUME @ STANDARD CONDITIONS*, dscm	0.4704			0.4306			0.3946		
AVERAGE GAS METER TEMPERATURE, °F	93			88			91		
ORIFICE PRESSURE DROP, in. H ₂ O.	0.684			0.573			0.484		
STACK STATIC PRESSURE, in. H ₂ O	+0.10			+0.10			+0.10		
AVERAGE STACK GAS TEMPERATURE, °F	1361			1270			1310		
AVERAGE STACK GAS VELOCITY, ft/s	19.6			18.1			16.9		
ISOKINETIC FACTOR, %	107.8			98.7			98.0		

*Standard Conditions are 20°C and 760 mm Hg

TABLE 2: SOURCE EMISSION SUMMARY

TEST NUMBER	1	2	3	AVERAGE
STACK GAS COMPOSITION DRY BASIS, % BY VOLUME				
CO ₂	8	8	8	-
O ₂	10.8	11.5	11.5	-
CO	0	0	0	-
STACK GAS MOISTURE, % BY VOLUME				
	13.9	11.2	10.6	-
M _s ** , g/g-mole				
	28.08	28.43	28.50	-
AVERAGE STACK GAS VOLUMETRIC FLOW RATE, dscm/h	999	999	918	972
CONCENTRATION OF PARTICULATE IN THE STACK GAS, g/dscm:				
AT STACK CO ₂	0.16	0.11	0.16	0.14
AT 12% CO ₂	0.24	0.17	0.24	0.22
EMISSION RATE OF PARTICULATE, kg/h				
	0.16	0.11	0.15	0.14

** Molecular Weight of the Stack Gas on a Wet Basis

DISCUSSION

The 1985 tests revealed a 15% reduction in average particulate emissions when compared to test results of the previous year. This could be due to the fact that the retort liner is now fully cured whereas in 1984 it may not have been.

CONCLUSION

The results of the three source emission tests indicate that during the survey the average particulate emission was 0.22 g/dscm when corrected to 12% CO₂ or 0.14 g/dscm at mean stack CO₂ values. When corrected to 12% CO₂ the particulate emission is below the Manitoba Regulation 334/74, Clause 3(1) limit of 0.23 g/dscm.

The average particulate emission rate was 0.14 kg/h.

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1. Reeve, Kevin E. Source Testing For Particulate Emissions From The Incinerator At Cara Operations Ltd., Winnipeg, Manitoba. Wpg., Mb: Manitoba Department of Environment and Workplace Safety and Health, 1983.
2. Retort Operating Instructions Model L-1701. Cleveland, Ohio: All Crematory Corporation, n.d.
3. Standard Reference Methods For Source Testing: Measurement Of Emission Of Particulates From Stationary Sources. Ottawa, Ont: Environment Canada, Environmental Protection Service, 1974 (Report EPS 1-AP-74-1).

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APPENDIX A

DRY GAS METER & OFFICE METER CALIBRATION SHEET

Dry Gas Meter S/N Bendix 711030
 Atmospheric Pressure 28.70 in. Hg at 729.0 mm. Hg
 Ambient Temperature 21.5°C

Lab No. 16399
 Calibrated re Larro Wet Test Meter
 Calibrated by Jim Redmond & Jim Higham
 Date 21 June 85

1/2

Manometer Crifice ΔH (in. H ₂ O)	W.G.M. Volume V _w (cc.)	Dry Gas Meter		D.G.M. Volume V _d (cc.)	Temperature				Time t		W.G.M. Manometer ΔP (in. H ₂ O)	Partial Pressure P ₂ (mm. Hg)	W.G.M. H ₂ O.M. Ratio γ (—)	$\sqrt{\quad}$ (—)	Flowrate F _{avg} (cc./min.)
		Reading			W.G.M. T _w (°C.)	D.G.M.		(min.)	(sec.)						
		Initial (cc.)	Final (cc.)			T ₁ (°C.)	T ₂ (°C.)								
0.490	3.0	779.98782	957	3.019	69.2	20.7	96	73	7.44.27	7.73.78	0.33	18.310	0.9947	0.5603	0.3799
0.485	3.0	783.96378	7.000	3.037	69.3	20.7	99	75	7.47.53	7.79.22	0.40	18.310	0.9930	0.5585	0.3785
0.485	3.0	788.02771	0.633	3.051	69.3	20.7	100	78	7.49.78	7.82.97	0.40	18.310	0.9920	0.5601	0.3788
1.00	4.0	773.07877	7.181	4.083	69.2	20.7	105	80	7.06.27	7.10.45	0.53	18.310	0.9932	0.8052	0.5579
1.00	4.0	778.20580	2.292	4.087	69.3	20.7	106	80	7.07.31	7.12.18	0.40	18.310	0.9933	0.8052	0.5561
1.50	4.0	803.32080	7.419	4.099	69.3	20.7	107	82	7.08.34	7.13.90	0.39	18.310	0.9931	0.8066	0.5574
1.52	4.0	807.47481	3.590	4.116	69.3	20.7	110	83	5.48.70	5.8.117	0.53	18.310	0.9909	0.9882	0.6848
1.52	4.0	814.12288	7.444	4.122	69.3	20.7	110	84	5.48.93	5.8.155	0.57	18.310	0.9902	0.9957	0.6855
1.52	4.0	820.27482	4.420	4.126	69.3	20.7	110	84	5.48.95	5.8.158	0.55	18.310	0.9893	0.9957	0.6855
2.00	5.0	825.70393	1.127	5.164	69.2	20.7	110	84	6.25.76	6.43.27	0.51	18.310	0.9872	1.1414	0.7740
2.00	5.0	832.15383	7.325	5.172	69.2	20.7	110	85	6.26.40	6.44.00	0.59	18.310	0.9863	1.1425	0.7744
2.00	5.0	838.35484	3.523	5.169	69.2	20.7	110	85	6.26.41	6.44.02	0.46	18.310	0.9872	1.1425	0.7746

Linear Regression: Intercept (b) 0.0173

Slope (K) 0.6626

Coefficient of Determination (r²) 0.9989

$\bar{\gamma}$ = 0.9886

ΔH_0 = 2.0932

Comments: _____

S-TYPE PITOT TUBE CALIBRATION

PROBE SIZE (ft) 5' SS Water Cooled CALIBRATION # 85 - 25

PROBE LINER SS DATE April 12, 1985

PROBE MANUFACTURER BENDIX

TIP SIZE (inches) 0.500

STACK THERMOCOUPLE ☒ PRESENT

☐ ABSENT

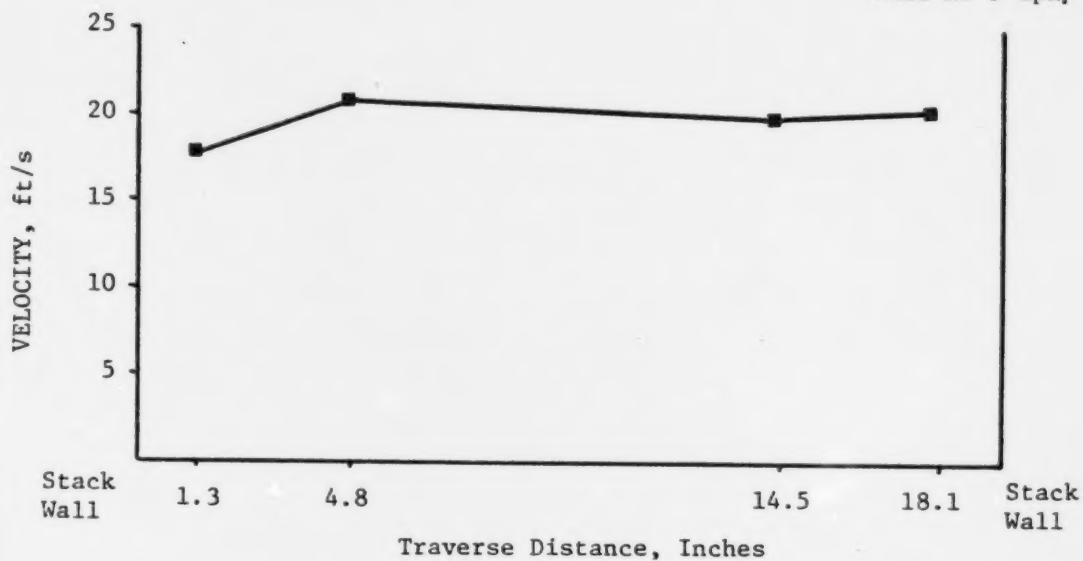
HP 97 INPUT/OUTPUT

Temp	21.3	°C	4	0.39	Δp (std)	8	1.24	Δp (std)
Bar. Press	29.36	In. Hg		13.286555			23.691411	
Scale	0.1			0.65	Δp (s-pitot)		1.96	Δp (s-pitot)
Factor				0.772660			0.793406	
				13.289339			23.696376	
1	0.10	Δp (std)	5	0.51	Δp (std)	9	1.72	Δp (std)
Tunnel Velocity	6.727909	ft/sec		15.193757			27.902576	
	0.17	Δp (s-pitot)		0.83	Δp (s-pitot)		2.67	Δp (s-pitot)
Cp, at this	0.765048	velocity		0.781914			0.800611	
Tunnel Velocity	6.729319	(using Cp)		15.196941			27.908424	
2	0.22	Δp (std)	6	0.69	Δp (std)			
	9.979101			17.672770				
	0.36	Δp (s-pitot)		1.11	Δp (s-pitot)		0.782451	Cp (ave)
	0.779782			0.786459			0.010850	Std. Dev.
	9.981192			17.676474			8	Deg. of Freedom
3	0.29	Δp (std)	7	0.84	Δp (std)			
	11.457215			19.499332			2.306	t .05
	0.48	Δp (s-pitot)		1.35	Δp (s-pitot)		0.774110	Low Cp
	0.775338			0.786839			0.782451	Mean Cp
	11.459617			19.503418			0.790791	High Cp

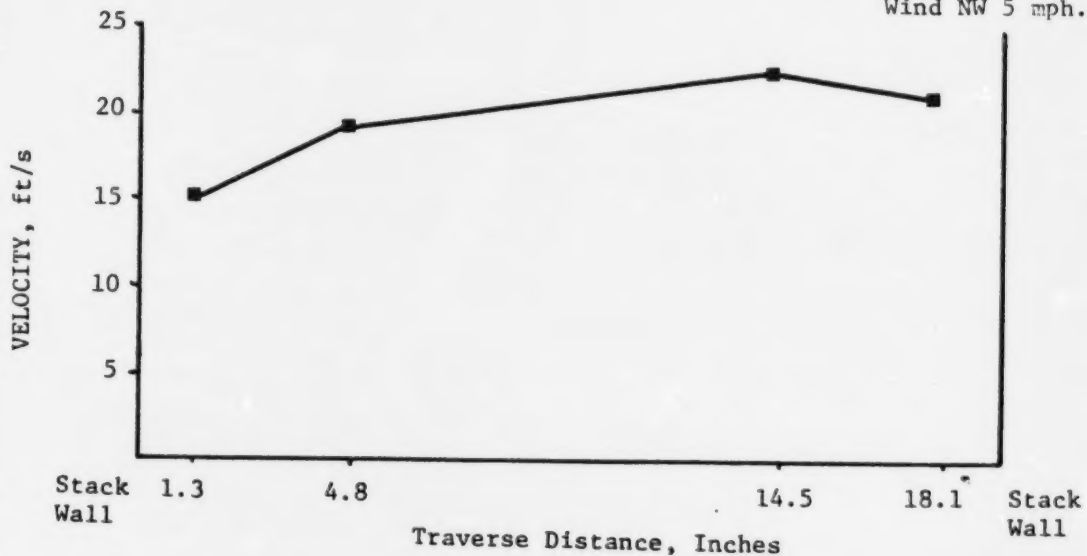
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APPENDIX B

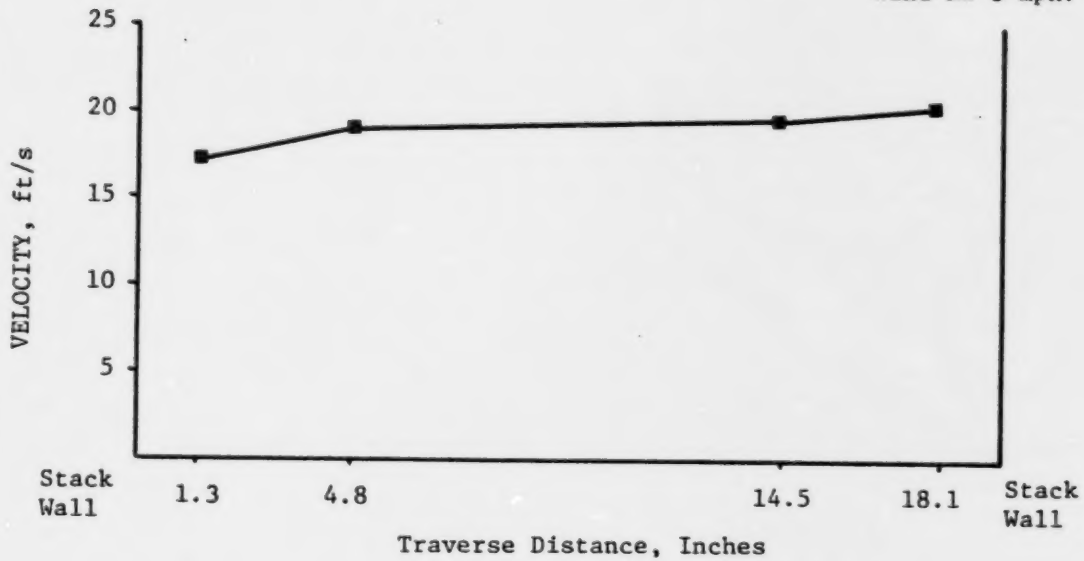
Graph 1. Velocity Profile of Test 1. Northwest Port.
Wind NW 5 mph.



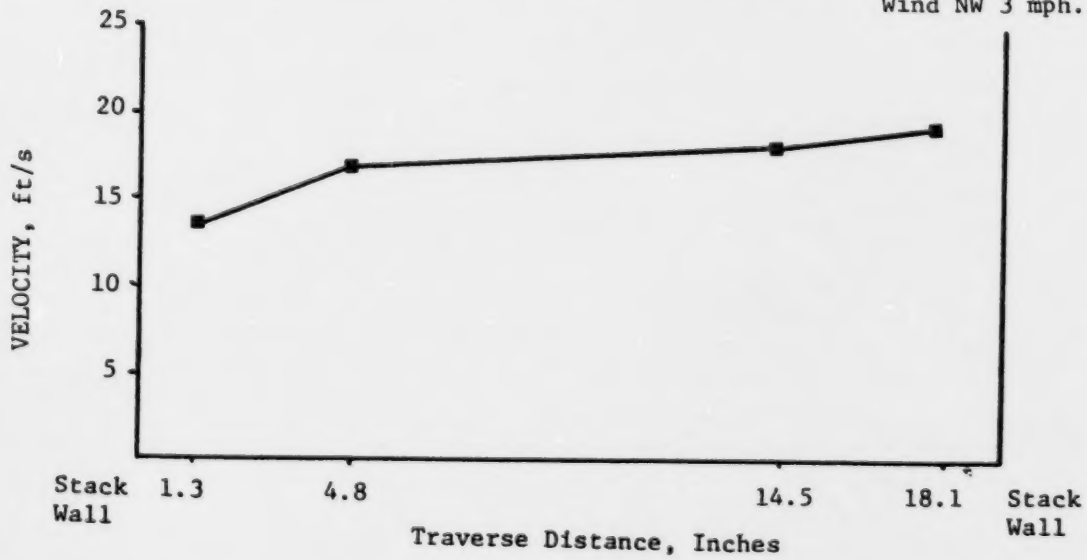
Graph 2. Velocity Profile of Test 1. Northeast Port.
Wind NW 5 mph.



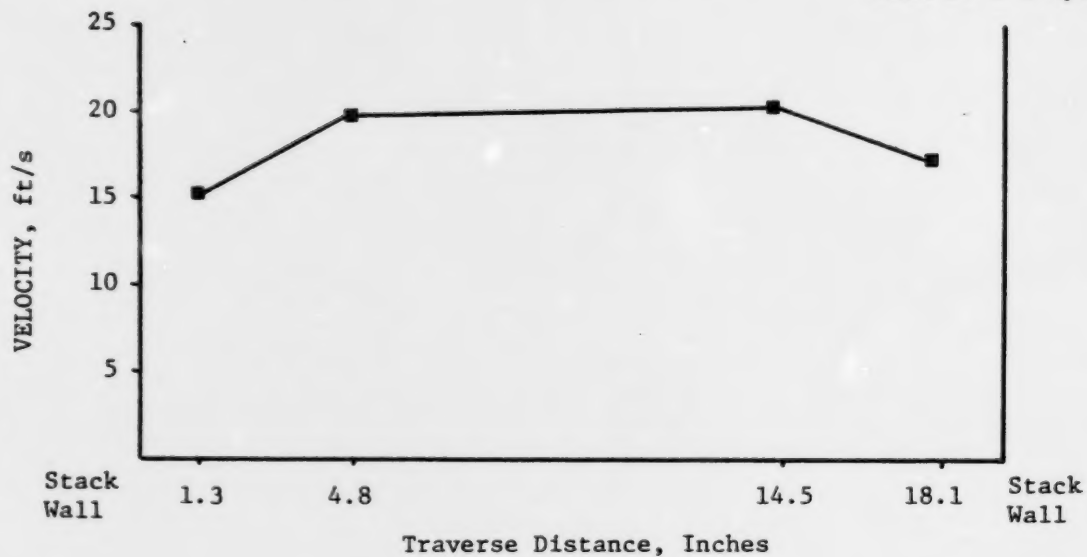
Graph 3. Velocity Profile of Test 2. Northwest Port.
Wind NW 3 mph.



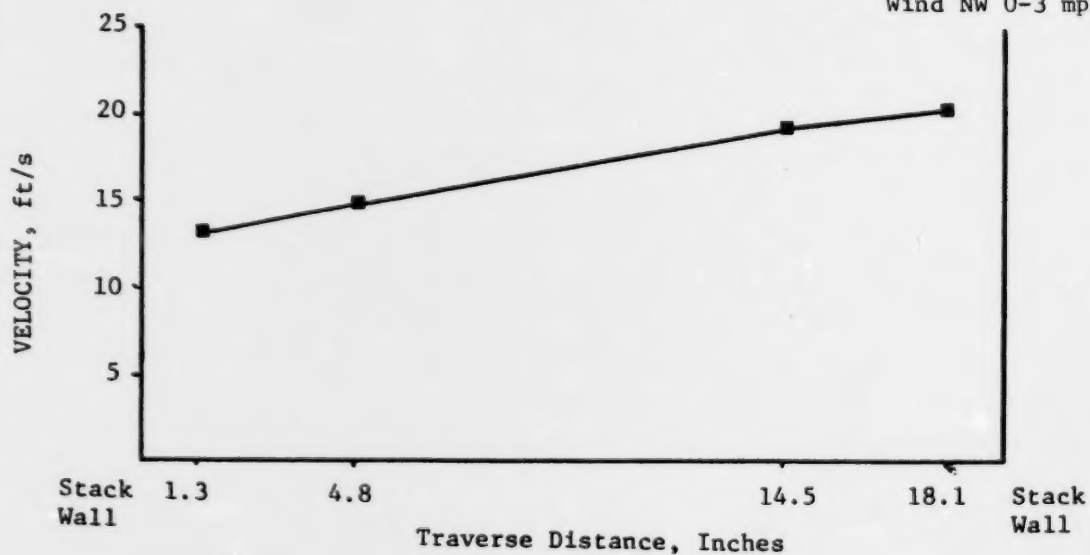
Graph 4. Velocity Profile of Test 2. Northeast Port.
Wind NW 3 mph.



Graph 5. Velocity Profile of Test 3. Northwest Port.
Wind NW 0-3 mph.



Graph 6. Velocity Profile of Test 3. Northeast Port.
Wind NW 0-3 mph.



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APPENDIX C

FIELD DATA SHEET

Plant Garry Memorial Crematorium Location 1291 McGillivray Boulevard, Winnipeg, Manitoba
 Stack East Crematory Test number 1 Date July 9, 1985
 Ambient temperature (°F) 76 Barometric pressure (in. Hg) 29.22 Time 1:49 P.M. to 2:42 P.M.
 Nozzle diameter (in.) 0.497 Probe length/type 5 foot/water cooled Stack static pressure (in. H₂O) +0.10
 Probe temperature (°F) ave. 113 Filter holder temperature (°F) ave. 270 Leak check 0000 CFM @ 15" Hg Vacuum

Traverse point number	Clock time, start	Stack gas temperature, °F	Gas meter volume, cu. ft.	Velocity pressure, in. H ₂ O	Orifice pressure drop in. H ₂ O	Gas meter temperature, °F Inlet Outlet	Final impinger Temperature, °F	Pump vacuum in. H ₂ O	Isokinetic factor, %
NW 1	0	1277	2.119	0.034	0.622	86 83	59	4	107.5
2	5	1356	2.290	0.041	0.721	98 83	56	4	107.2
3	10	1390	2.262	0.040	0.696	102 84	55	4	108.2
4	15	1422	2.280	0.041	0.696	104 84	55	4	107.9
NE 1	20	1299	1.770	0.024	0.433	92 88	66	3	106.9
2	25	1358	2.188	0.037	0.657	102 88	61	4	107.1
3	30	1402	2.555	0.050	0.864	107 88	60	5	108.3
4	35	1384	2.442	0.045	0.783	108 89	63	5	108.9
Average or total	40	1361	17.906	0.039	0.684	100 85	-	-	107.8

FIELD DATA SHEET

Plant Garry Memorial Crematorium Location 1291 McGillivray Boulevard, Winnipeg, Manitoba.
 Stack East Crematory Test number 2 Date July 10, 1985
 Ambient temperature (°F) 68 Barometric pressure (in. Hg) 29.15 Time 10:05 A.M. to 10:56 A.M.
 Nozzle diameter (in.) 0.497 Probe length/type 5 foot/water cooled Stack static pressure (in. H₂O) +0.10
 Probe temperature (°F) ave. 121 Filter holder temperature (°F) ave. 272 Leak check 0.000 CFM @ 15" Hg Vacuum

Traverse point number	Clock time, start	Stack gas temperature, °F	Gas meter volume, cu. ft.	Velocity pressure, in. H ₂ O	Orifice pressure drop in. H ₂ O	Gas meter temperature, °F Inlet Outlet	Final impinger Temperature, °F	Pump vacuum in. H ₂ O	Isokinetic factor, %
NW 1	0	1191	2.032	0.034	0.571	78 74	57	4	99.3
2	5	1253	2.171	0.040	0.648	87 74	56	4	99.0
3	10	1302	2.153	0.041	0.645	94 74	56	4	98.0
4	15	1350	2.205	0.043	0.663	97 76	57	4	98.6
NE 1	20	1194	1.571	0.021	0.354	86 80	62	3	96.6
2	25	1261	1.954	0.032	0.524	93 80	62	3	98.8
3	30	1304	2.037	0.035	0.557	98 80	63	3	99.5
4	35	1302	2.162	0.039	0.619	100 80	62	4	100.0
Average or total	40	1270	16.285	0.036	0.573	91 77	-	-	98.7

FIELD DATA SHEET

Plant Garry Memorial Crematorium Location 1291 McGillivray Boulevard, Winnipeg, Manitoba.
 Stack East Crematory Test number 3 Date July 10, 1985
 Ambient temperature (°F) 71 Barometric pressure (in. Hg) 29.16 Time 1:22 P.M. to 2:10 P.M.
 Nozzle diameter (in.) 0.497 Probe length/type 5 foot/water cooled Stack static pressure (in. H₂O) +0.10
 Probe temperature (°F) ave. 117 Filter holder temperature (°F) ave. 254 Leak check 0.000 CFM @ 15" Hg Vacuum

Traverse point number	Clock time, start	Stack gas temperature, °F	Gas meter volume, cu. ft.	Velocity pressure, in. H ₂ O	Orifice pressure drop in. H ₂ O	Gas meter temperature, °F		Final impinger Temperature, °F	Pump vacuum in. H ₂ O	Isokinetic factor, %
NW 1	0	1278	1.704	0.025	0.406	Inlet	Outlet	70	3	97.4
2	5	1342	2.150	0.040	0.630	93	84	64	3	98.5
3	10	1516	2.024	0.038	0.556	98	84	62	3	99.3
4	15	1310	1.861	0.030	0.481	101	84	65	3	97.1
NE 1	20	1190	1.558	0.020	0.340	94	86	70	2	96.7
2	25	1237	1.759	0.025	0.416	98	86	70	3	98.3
3	30	1311	1.879	0.030	0.477	103	86	68	3	97.7
4	35	1292	2.066	0.035	0.566	104	86	67	4	99.1
Average or total	40	1310	15.001	0.030	0.484	97	85	-	-	98.0

APPENDIX D

From SAMPLE - 1D To

Y	Sequent
ES	179POL

Y	Sequent
ES	179POL

Date Sampled Date Received

Y	M	D
85	6	7

Y	M	D
85	6	7

[illegible]

Chemist Signature [Signature] Date 5-5-87

SUBMITTER: KEVIN REEVE
LOCATION: GARRY CREMATORIUM (TEST # 2)
REPORT TO: KEVIN REEVE

From SAMPLE - 1D To

Y	Sequent
85	179903

Y	Sequent
85	179903

Date Sampled Date Received

Y	M	D
85	07	16

Y	M	D
85	07	16

L - Less than
G - Greater than

Sample Number	Identification or Comments	Parameter	L/G	Value	Units	Date Analyzed
17903	BOTTLE #1 - Probe washings + Glassware before Filter.	TSP		0.10335	g	8/27/17
17904	BOTTLE #2 - Impinger 1 and 2 contents.	TSP		0.1072	g	8/27/17
17905	FILTER #445	TSP		0.10145	g	8/27/17

Date 5-5-68

Chemical Synthesis

From SAMPLE - 1D To

Y	Sequent
85	17906

Y	Sequent
85	17908

Date Sampled Date Received

Y	M	D
85	5	15

Y	M	D
85	5	15

L - Less than
G - Greater than

Chemist Signature W. J. [Signature] Date 5-18-67